



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2360
Job Sheet 175879



Part No: D2360

Job Qty: 2 ea

Part Name: Litter Tie Down Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 4/11/18

Job Tracking No:

Due Date: 4/12/18

Created By: Jason Leroux

Type: SOLD

Description:

Note: DWG D2341 REV G, D2360 REV D IPP rev H 07.06.12 ecn 825 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier		Sign-off
					Setup Run hrs Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	4/11/18	4/11/18	0.00 0.00	Start Up Machining		SBL 18/04/11
100	Bandsaw	2 pcs	4/11/18	4/11/18	0.00 0.07	Bandsaw1		SBL 18/04/11
110	CNC Vertical Machining	2 pcs	4/11/18	4/11/18	0.26 2.99	HAAS 1		SBL 18/04/11
120	QC	2 pcs	4/11/18	4/11/18	0.00 0.00	QC2		SBL 18-04-11
130	QC	2 pcs	4/11/18	4/11/18	0.00 0.00	QC8		SBL 18-04-12
140	HandFinish	2 pcs	4/11/18	4/11/18	0.00 0.16	HandFinish1		SBL 18-04-12
150	Powdercoat	2 pcs	4/11/18	4/11/18	0.00 0.12	Powdercoat1		SBL 18-04-12
160	QC	2 pcs	4/11/18	4/11/18	0.00 0.00	QC3		SBL 18-04-12
170	Small Fab	2 pcs	4/12/18	4/12/18	0.00 0.63	Small Fab		SBL 18-04-12
180	QC	2 pcs	4/12/18	4/12/18	0.00 0.00	QC5		SBL 18-04-12
190	Packaging	2 pcs	4/12/18	4/12/18	0.00 0.00	Packaging3	5/22/18	APR 13 2018
200	QC21-SA	2 Ea	4/12/18	4/12/18	0.00 0.00	QC21		APR 13 2018

Part Op 100 - Cut blanks: 12.65" Long

Descriptions: 110 - Machine as per Folio D2341 and Dwg D2341

150 - START TIME: 11:30

170 - Assemble as per dwg D2360

1x 5047998 -> 5060112

1x 5053647 -> 5060113

002472



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Container No: S060114



Part: D2360

Job No: 175879

Serial No/Batch: S060114

Revision:

Inspector:

Date: 04/11/18

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6201	T Extrusion	2.1080 ft (1.054 ea)	90-Start up Operation	
AN526C1032R18	Screw	2 Ea (1 ea)	170-Small Fab	5041062 F108079
D2002-015	Knob	4 Ea (2 ea)	170-Small Fab	5054918 F1618 04 X
D2345	Lock Channel	2 Ea (1 ea)	170-Small Fab	5054918
D2366	Lock Handle	4 Ea (2 ea)	170-Small Fab	50411478
D2367	Handle Knob	2 Ea (1 ea)	170-Small Fab	F155483
D2372	Quick Release	4 Ea (2 ea)	170-Small Fab	F1635514
D2373	Spring	2 Ea (1 ea)	170-Small Fab	F158069X1 503946 X
D2444	Pip Pin Assembly 12+	2 Ea (1 ea)	170-Small Fab	5041321
MS20470AD3-4	Rivet, Universal Head	2 Ea (1 ea)	170-Small Fab	F1136665-40
MS21042L3	Nut	6 Ea (3 ea)	170-Small Fab	5038164
MS27039-1-13	Screw	2 Ea (1 ea)	170-Small Fab	F125650
MS27039-1-15	Screw	4 Ea (2 ea)	170-Small Fab	5023923
NAS1149D0332J	Washer	16 Ea (8 ea)	170-Small Fab	5020606
NAS1149D0363J	Washer	4 Ea (2 ea)	170-Small Fab	5015269
NAS679A3W	Nut	2 Ea (1 ea)	170-Small Fab	FM24109

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6201	2	34	0
170-Small Fab	AN526C1032R18	2	110	0
	D2002-015	4	49	0
	D2345	2	12	0
	D2366	4	53	0
	D2367	2	29	0
	D2372	4	29	0
	D2373	2	31	0
	D2444	2	8	0
	MS20470AD3-4	2	6,953	0
	MS21042L3	6	2,520	0
	MS27039-1-13	2	397	0
	MS27039-1-15	4	388	0
	NAS1149D0332J	16	3,168	0
	NAS1149D0363J	4	2,818	0
	NAS679A3W 6A020	2	143	0

Part Specifications

Specifications could not be found.

Plex 4/11/18 12:57 PM dart.leroux.jason

2018

DART AEROSPACE LTD		Work Order:
Description: Litter Tie Down Bracket (Locking)		Part Number: D2341
Inspection Dwg: D2341	Rev: G	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.750	+/-0.010	1.75	✓			
2.75	+/-0.030	2.755	✓			
Ø0.246	+0.005/-0.001	0.246	✓			
Ø0.191	+0.005/-0.001	0.193	✓			
R0.25	+/-0.030	0.250	✓			
R0.40	+/-0.030	0.400	✓			
12.50	+/-0.030	12.500	✓			
11.750	+/-0.010	11.753	✓			
11.00	+/-0.030	11.003	✓			
7.00	+/-0.030	7.003	✓			
6.250	+/-0.010	6.253	✓			
5.50	+/-0.030	5.500	✓			
1.50	+/-0.030	1.503	✓			
0.750	+/-0.010	0.750	✓			
0.400	+/-0.010	0.399	✓			
1.584	+/-0.010	1.580	✓			
2.610	+/-0.010	2.606	✓			
0.250	+/-0.010	0.249	✓			
0.844	+/-0.010	0.844	✓			
Ø0.250	+/-0.010	0.250	✓			
0.750	+/-0.010	0.750	✓			
3.313	+/-0.010	3.305	✓			
4.250	+/-0.010	4.247	✓			
1.250	+/-0.010	1.247	✓			

Measured by: SBL/B.P.	Checked by: S.S.	QC Inspector:
Date: 18/04/11	Date: 18-04-12	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	06.05.24	New Issue P/O D2360	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	10.02.02	Dimensions updated	KJ	
D	16.06.14	Dimensions updated per Dwg Rev G	KJ	

DuA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐			FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER :					



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
002472	S060483	AN526C1032R18	Screw	F108079	ST326	2
002472	F164804	D2002-015	Knob		GA126	1
002472	S060493	D2002-015	Knob	S041062	GA126	3
002472	S060482	D2345	Lock Channel	S054918	GA127	2
002472	S060481	D2366	Lock Handle	S041478	ST006	4
002472	S060480	D2367	Handle Knob	F155485	ST006	2
002472	S060494	D2372	Quick Release	F165514	GA117	4
002472	F158069	D2373	Spring		GA127	1
002472	S060495	D2373	Spring	S054946	GA127	1
002472	S060479	D2444	Pip Pin Assembly	S041321	GA127	2
002472	S060478	MS20470AD3-4	Rivet, Universal Head	FM136665-40	ST310	2
002472	S060477	MS21042L3	Nut	S038764	ST303	6
002472	S060476	MS27039-1-13	Screw	F125654	ST280	2
002472	S060475	MS27039-1-15	Screw	S003923	ST280	4
002472	S060474	NAS1149D0332J	Washer	S020606	ST264	16
002472	S060473	NAS1149D0363J	Washer	S015269	ST263	4

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 4/12/18 1:25 PM dart.quirion.sonia